

Date: Thursday, 2/14/2008 2:21:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP INSTALLATION KIT
Job Number : 37456	
Estimate Number : 10542	
P.O. Number :	Part Number : K591113
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D350-591 REV F PG17
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 35319	Material :
Written By :	Due Date : 3/15/2008 Qty: 14 Um: Each
Checked & Approved By : <u>AS 08 02 14</u>	
Comment : Est: C 04.11.09 Reformat KJJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2171	Clamp
<u>7/14</u>		

Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description	Batch
2	D2171	Clamp	33936

AS 08/03/17 (14)

2.0	D2182B	Neoprene Cushion-.750 bl
<u>7/14</u>		

Comment: Qty.: 0.5833 f(s)/Unit Total : 8.1662 f(s)

Neoprene Cushion-.750 bl

Pick:

Qty	Part Number	Description	Batch
7"(2 x 3.5")	D2182B	Cushion	35769

AS 08/03/17 (14)

3.0	D2274	Radius Block
<u>7/14</u>		

Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Radius Block

Pick:

Qty	Part Number	Description	Batch
4	D2274	Radius Block	36624

AS 08/03/17 (14)

4.0	D23623	Step Support Bracket
<u>7/14</u>		

Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Step Support Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2362-3	Support Bracket	11X B37459 3 B35328

not enough in temp But all the same.

AS 08/03/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SHORT STEP INSTALLATION KIT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 8.4000 f(s)

Abrasion Strip

Pick:

Qty Part Number Description Batch

7.2" (QTY 1) D2856-400 Abrasion Strip

36161

AS

08/03/17

(X14)

6.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3-37A Bolt

M104016

AS

08/03/17

(X14)

7.0

AN420A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

4 AN4-20A Bolt

M16895

AS

08/03/17

(X14)

8.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

1 AN4-22A Bolt

M104937

AS

08/03/17

(X14)

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer

M106552

AS

08/03/17

(X14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:38 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 84.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	AN960JD416	Washer	M106277

AS 08/03/17 (x14)

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M106242

AS 08/03/17 (x14)

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 70.0000 Each(s)

Need fixing in Comp.
2 Batches.

Nut

Pick:

Qty	Part Number	Description	Batch
5	MS21042L4	Nut	M105938 x30

M106825 x40

AS 08/03/17 (x14)

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P- 4/3/18 (14)

PRR 37076

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/17

Job Completion



2008/3/18

(14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1		1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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